

Date: Friday, 01/05/2009 11:20:04 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LONG PIN BRACKET
Job Number : 47650	
Estimate Number : 11204	
P.O. Number :	Part Number : D333011
This Issue : 01/05/2009 S.O. No. :	Drawing Number : D3330 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 45327	Material :
Written By :	Due Date : 18/05/2009 Qty: 10 Um: Each
Checked & Approved By : <u>DD 09.05.01</u>	
Comment : Est. A05.01.13 New issue KJ/JLM est b 07.05.14 rev c dwg ec est C 07.12.12 rev D dwg EC verified by:DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010B2500X01000	1010-1025 Steel Bar 2.50 x 1.00
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Comment: Qty.: 0.4437 f(s)/Unit Total : 4.4373 f(s)
1010-1025 Steel Bar
Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 Cold Rolled Steel(
M1010-B2.500x01.000)
Identify for D3330-11
Batch: 110470 110740

88 09/05/04 (10)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
Cut blanks: 2.500" x 1.000" x 5.00" long (+/-0.030)

88 09/05/04 (10)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per Folio FA479 and Dwg D3330
Identify as D3330-11
Deburr

DT 09/05/05 (10) (P10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DT 09/05/05 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3330-11 PAR #: N/A Fault Category: Prod/Eng Coord NCR: (Yes) No DQA: (Signature) Date: 08/05/08
 Resolution: Process failed Disposition: Scrap QA: N/C Closed: (Signature) Date: 09/05/08

NCR: <u>47650</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/05/06	3.0	During the boring process the part sh. fluted in the hole became oval. Feed was too fast. R.C. program.	<u>(Signature)</u> 08/04/08	Scrap & replace Qty 1 M <u>110740</u> + Program fixed to reduce Feed speed	<u>(Signature)</u> 09/05/06	<u>(Signature)</u> 09/05/08	<u>(Signature)</u> 08/04/08	<u>(Signature)</u> 09/05/06

NOTE: Date & initial all entries

Date: Friday, 01/05/2009 11:20:04 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG PIN BRACKET

Job Number: 47650

Part Number: D333011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND.CHECK

SB 09/05/07

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Cars 1

pls

102

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/08

Job Completion



MF
09-05-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47650
Description: Long Pin Bracket		Part Number: D3330-11
Inspection Dwg: D3330	Rev: 2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.00	+/-0.030	4.999	✓			
4.625	+/-0.010	4.625				
0.260	+/-0.010	0.260	✓			
Ø0.594	+0.005/-0.000	0.594	✓			
0.875	+/-0.010	0.869	✓			
0.838	+/-0.010	0.842	✓			
0.700	+/-0.010	0.696	✓			
0.500	+/-0.010	0.504	✓			
2.25	+/-0.030	2.251	✓			
0.950	+/-0.010	0.951	✓			
Ø0.531	+0.005/-0.000	0.536	✓			
Ø0.348	+0.005/-0.000	0.349	✓			
Ø0.516	+0.005/-0.000	0.517	✓			
0.467	+/-0.010	0.465	✓			
1.250	+/-0.010	1.250	✓			
1.00	+/-0.030	0.997	✓			
0.10 x 45°	+/-0.5°	0.100x45°	✓			

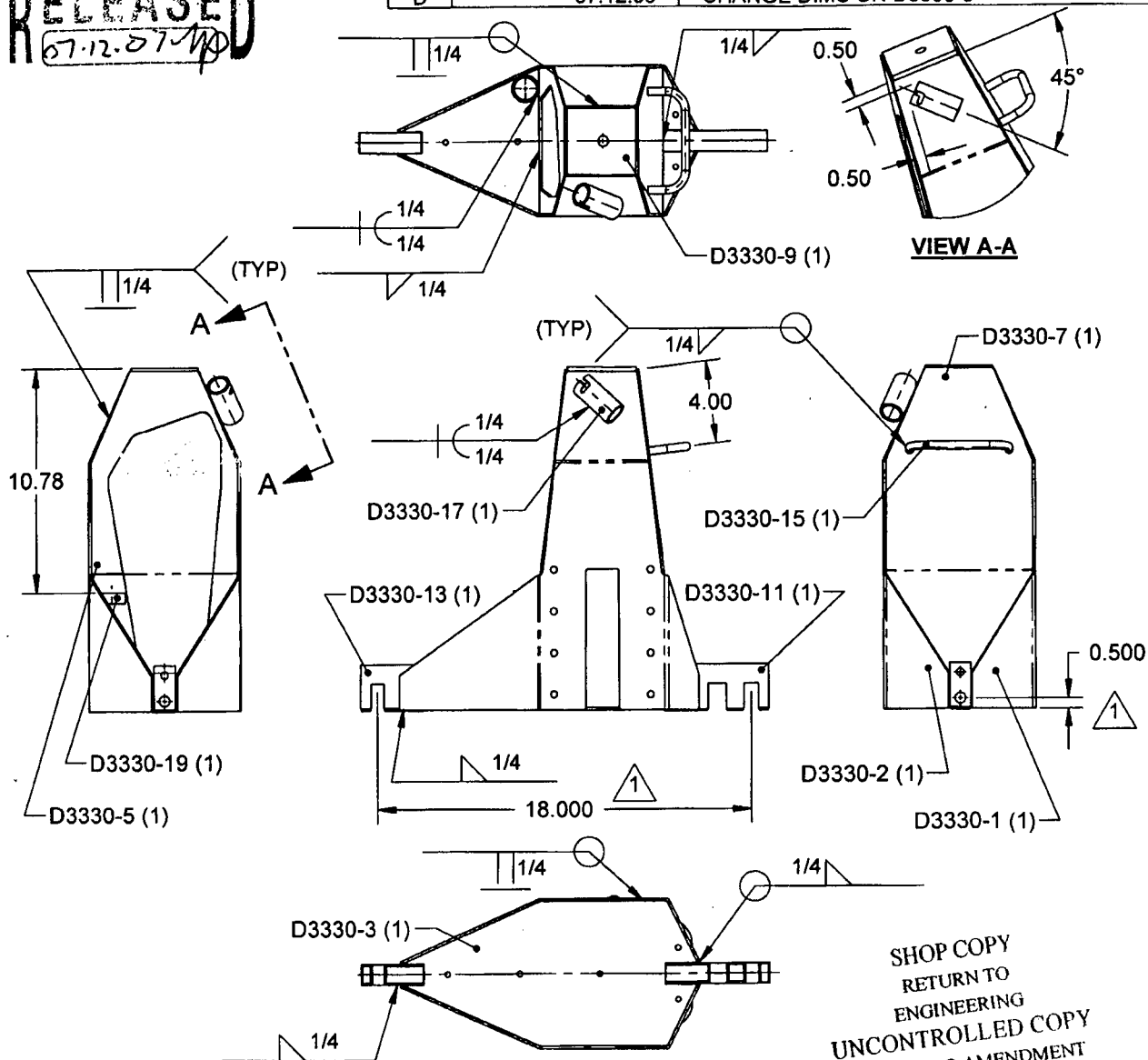
Measured by: DIP	Audited by: df	Prototype Approval:	N/A
Date: 09/05/05	Date: 09/05/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.05.10	New Issue	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	07.05.16	Dwg Rev updated	KJ/EC	
D	07.11.23	0.838 was 0.837	KJ/EC/DD	



DESIGN <i>13</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>13</i>	APPROVED <i>13</i>	DRAWING NO. D3330	REV. D SHEET 1 OF 9
DATE 07.12.06	TITLE FRAME WELDMENT	SCALE 1:8	
REV	DATE	DESCRIPTION	
A	04.12.16	NEW ISSUE	
B	05.02.26	RE-DESIGN	
C	07.03.20	ADD 0.100 DIM; RAISED BEND OF -1/2 BY 0.125	
D	07.12.06	CHANGE DIMS ON D3330-9	

RELEASED
07.12.07



D3330-041 FRAME WELDMENT

NOTES:

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

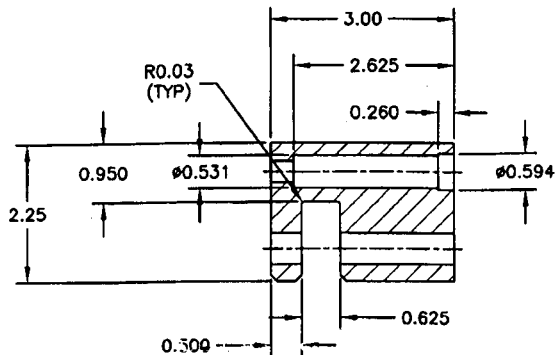
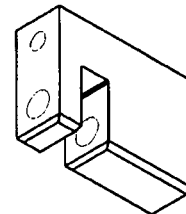
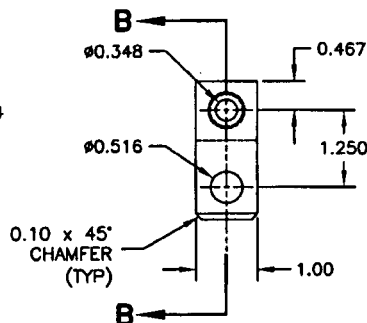
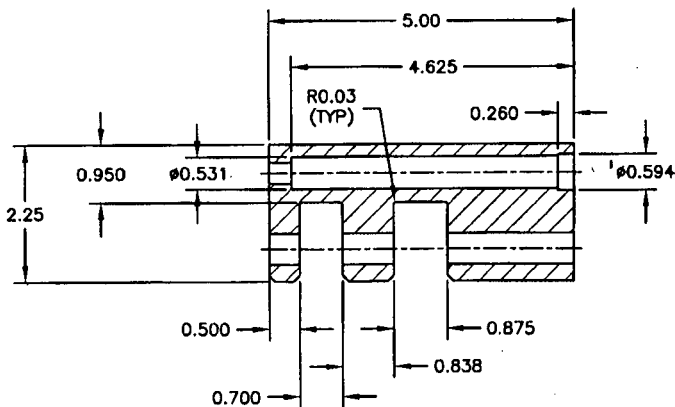
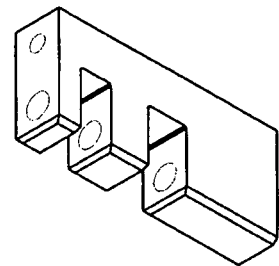
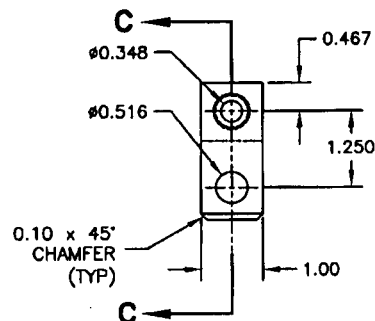
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WORK ORDER
NO. *471050*

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DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3330	REV. D SHEET 9 OF 9
DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:3

RELEASED
07.12.07**SECTION B-B****D3330-13 SHORT PIN BRACKET****SECTION C-C****D3330-11 LONG PIN BRACKET**

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NO. *167050*

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL (REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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